



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D117-837-011
Job Sheet 168133



000358

Part No: D117-837-011

Job Qty: 1 ea

Part Name: BK117 Quick Release Heli-Utility-Basket™ Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 1/3/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Heli-Inter Inc (CHINT01)

6500 Chemin De La Savane St Hubert, QC, J3Y 8Y9 Canada ph:(450) 468-3431

Ship Via:

AS19716 REV A / IIN-D117-837 REV B

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/3/18	0.00	0.00	Start Up Stores/Pkg1		
110	Packaging	1 pcs		1/3/18	0.00	0.00	Packaging1		
120	QC	1 pcs		1/3/18	0.00	0.00	QC4		SMB
125	DC	1 pcs		1/3/18	0.00	0.00	DC		
130	Packaging	1 pcs		1/3/18	0.00	0.00	Packaging3		SMB
140	QC21-FG	1 Ea		1/3/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile & type labels per PPP D117-837-011 CHG006

Descriptions: 130 - Identify and pack for shipping as per PPP D117-837-011 Location: _____

FEB 2 2018

fg 030

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- AN3-11A	2	125	0	0
	- AN4-12A	4	108	0	0
	- D117-837-111	1	1	0	0
	- D4784-011	1	0	0	0
	- D5106-041	4	4	0	0
	- D5203-041	1	1	0	0
	- D5204-1	2	8	0	0
	- D5205-1	1	3	0	0
	- MS21042-3	2	39	0	0
	- MS21042L4	4	1,624	0	0
	- MS21069L3	8	94	0	0
	- MS27039-1-08	8	461	0	0
	- NAS1097AD34	16	7,574	0	0
	- NAS1149D0416J	8	3,504	0	0
	- NAS1149F0332P	2	2,740	0	0
	- NAS1149F0832P	2	960	0	0

Part Specifications

Specifications could not be found.

Plex 11/9/17 4:54 PM dart.poulin.mario

Basket Assembly. 168154

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																					
Description Work Order Deviation																																																									
Start up Operation Job No: 168133 02/09/18 Operation: Revision: Original Serial #: S041005 PART NO: D117-837-011 Change No: CHG006 BK117 Quick Release Heli - Utility - Basket Fits LH or RH S041005 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																									
Completed By _____																																																									
Lead hand / Supervisor Approval Verification _____																																																									
QC / QA Coordinator Approval _____																																																									
<table style="width:100%; font-size: x-small;"> <tr> <th colspan="2" style="text-align: left;">Root Cause</th> <th colspan="2"></th> </tr> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;">Pre ☐</td> <td style="width:15%;"></td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Ber ☐</td> <td></td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Cer ☐</td> <td></td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Crai ☐</td> <td></td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crin ☐</td> <td></td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuff ☐</td> <td></td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="2"></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td colspan="2"></td> </tr> </table>						Root Cause				Environment ☐	No Re-verification ☐	Pre ☐		Design ☐	Operator ☐	Ber ☐		Doc/Data ☐	Offset/Setup ☐	Cer ☐		Equip/Tooling ☐	Supplier ☐	Crai ☐		Handling/Pre ☐	Training ☐	Crin ☐		Material ☐	Use for Testing ☐	Cuff ☐		Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐		
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000358

Tel (613) 632-5200

Containers on Master Unit 000358				
Serial No	Part No	Customer Part No	Status	Quantity
S037982	AN3-11A		Allocated	2
S037978	AN4-12A	AN4-12A	Allocated	4
S037963	D5106-041		Allocated	4
S036819	D5203-041	D5203-041	Allocated	1
S037958	MS21042-3	MS21042-3	Allocated	2
S037954	MS21042L4	MS21042L4	Allocated	4
FM137820-1	MS21069L3		Allocated	8
S037935	MS27039-1-08	MS27039-1-08	Allocated	8
S037934	NAS1097AD34		Allocated	16
S037927	NAS1149D0416J	NAS1149D0416J	Allocated	8
S037922	NAS1149F0332P		Allocated	2
S037921	NAS1149F0832P		Allocated	2

D5204-1 F132999x1 Not used S043571
D5205-1 S042608
117 B57-111 S034122
D1784-04 S038176

REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty -111	Part Number	Description
X			D117-837-011	HELI-UTILITY-BASKET, LH/RH
	X		D117-837-013	PROP ARM KIT
1		X	D117-837-111	BASKET PROVISION MOUNTING KIT
	1*		D2332-041	PROP ASSEMBLY (OPTIONAL)
	4*		D3953-9	WASHER
1			D4784-011	BASKET ASSEMBLY, HEAVY DUTY, LH/RH
1			D4794-043	STRUT ASSY
		2	D4893-1	HARDPOINT ADAPTER, LH
		2	D4893-2	HARDPOINT ADAPTER, RH
		1	D4894-1	FWD BEAM
		1	D4894-3	AFT BEAM
		1	D4895-045	FWD OUTBOARD BEAM ASSY
		1	D4895-047	AFT OUTBOARD BEAM ASSY
1			D4911-1	BRACKET
2			D4911-3	BRACKET
4			D5106-041	BRACKET ASSY
2			AN3-11A	BOLT
4			AN4-12A	BOLT
		4	AN4-17A	BOLT
		12	AN5-23A	BOLT
		12	MS20002C6	WASHER
2			MS21042-3	NUT
4		4	MS21042L4	NUT
		12	MS21042L5	NUT
		12	MS21042L6	NUT
4			MS21069L3	ANCHOR NUT
		12	MS21250-06022	BOLT
4			MS27039-1-08	SCREW
8			NAS1097AD3-4	RIVET
	3*		NAS1149C0463R	WASHER (or AN960C416)
8		8	NAS1149D0416J	WASHER (or AN960JD416L)
		24	NAS1149D0516J	WASHER (or AN960JD516L)
		12	NAS1149D0616J	WASHER (or AN960JD616L)
6			NAS1149F0332P	WASHER (or AN960-10L)

* D2332-041 PROP ASSEMBLY & HARDWARE (OPTIONAL) TO REPLACE D3969-3 GAS SPRING

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Revision: B

Date: 14.06.24

4.0 Parts List

For D117-837-011 Heli-Utility-Baskets @ CHG 005, the Parts List in ICA-D117-837 and IIN-D117-837 (as modified per DSI 9706 Rev. A) should be updated as follows:

Qty -011	Part Number	Description
X	D117-837-011	HELI-UTILITY-BASKET, LH/RH
1	D4784-011	BASKET ASSEMBLY, HEAVY DUTY, LH/RH
4	D5106-041	BRACKET ASSY
1	D5203-041	STRUT ASSY (REPLACES D4794-043)
2	D5204-1	BRACKET
1	D5205-1	BRACKET
2	AN3-11A	BOLT
4	AN4-12A	BOLT
2	NAS1149F0332P	WASHER
8	NAS1149F0416P	WASHER
2	NAS1149F0832P	WASHER
2	MS21042L3	NUT
4	MS21042L4	NUT

For D117-837-011 Heli-Utility-Baskets @ CHG 002 thru CHG 004, the DSI 9716-011 Strut Relocation Kit is available from Dart.

Qty -011	Part Number	Description
X	DSI 9716-011	STRUT RELOCATION KIT
1	D5203-041	STRUT ASSY (REPLACES D4794-043)
2	D5204-1	BRACKET
1	D5205-1	BRACKET
2	AN3-11A	BOLT
2	NAS1149F0332P	WASHER
2	NAS1149F0832P	WASHER
2	MS21042L3	NUT

5.0 Weight & Balance

This DSI has a negligible effect on Weight & Balance

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.06
CERT. NO.: SH13-22
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	HS	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9716 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		STRUT RELOCATION NTS
DATE	15.01.06	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

REFERENCE ONLY

4.0 Parts List

For D117-837-011 Heli-Utility-Baskets @ CHG 004, the Parts List in ICA-D117-837 and IIN-D117-837 should be updated as follows:

IS

Qty -011	Part Number	Description
X	D117-837-011	HELI-UTILITY-BASKET, LH/RH
2	D4911-5	BRACKET (REPLACES D4911-3)
8	MS21069L3	ANCHOR NUT
8	MS27039-1-08	SCREW
16	NAS1097AD3-4	RIVET
10	NAS1149F0332P	WASHER

WAS

Qty -011	Part Number	Description
X	D117-837-011	HELI-UTILITY-BASKET, LH/RH
2	D4911-3	BRACKET
4	MS21069L3	ANCHOR NUT
4	MS27039-1-08	SCREW
8	NAS1097AD3-4	RIVET
6	NAS1149F0332P	WASHER

For D117-837-011 Heli-Utility-Baskets @ CHG 002 or CHG 003, the DSI 9706-011 Basket Modification Kit is available from Dart.

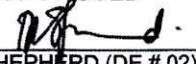
Qty -011	Part Number	Description
X	DSI 9706-011	BRACKET MODIFICATION KIT
2	D4911-5	BRACKET
8	MS21069L3	ANCHOR NUT
8	MS27039-1-08	SCREW
16	NAS1097AD3-4	RIVET
8	NAS1149F0332P	WASHER

5.0 Weight & Balance

This DSI has a negligible effect on Weight & Balance

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.09.03
CERT. NO.: SH13-22
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	HS	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9706 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		BRACKET MODIFICATION NTS
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